

GU20加工案例
GU20 Case Study

模具钢(40HRC)铣削加工
Milling Die Steel (40HRC)

加工信息 Working Conditions	工件材质 Work Piece Material		刀具类型 Tool Type	牌号 Grade	
	模具钢 Die Steel Skd61 (40hrc)		立铣刀 Endmill	GU20	
	刃径D Mill Dia.(mm)	刃长Lc Flute Length(mm)	刃数 Number of Flutes(n)	涂层 Coating	冷却 Cooling
	8	20	4	AlCrN	Water Soluble

GU25UF加工案例
GU25UF Case Study

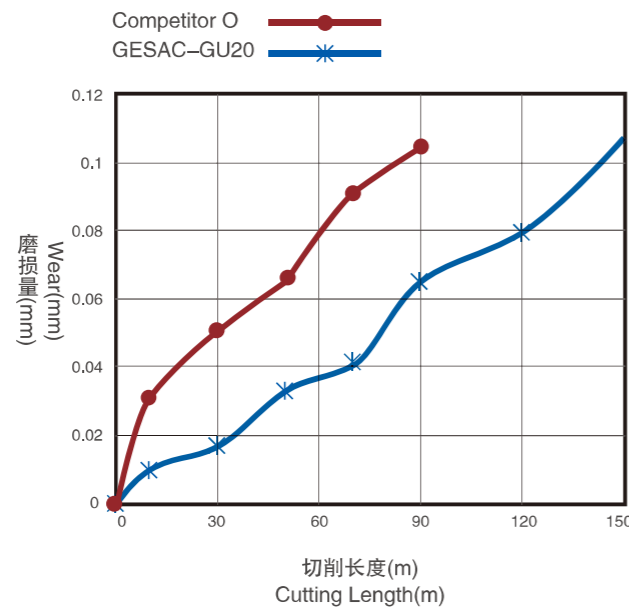
模具钢(55HRC)铣削加工
Milling Die Steel (55HRC)

加工信息 Working Conditions	工件材质 Work Piece Material		刀具类型 Tool Type	牌号 Grade	
	模具钢 Die Steel SKD61 (55HRC)		立铣刀 Endmill	GU25UF	
	刃径D Mill Dia.(mm)	刃长Lc Flute Length(mm)	刃数 Number of Flutes(n)	涂层 Coating	冷却 Cooling
	6	-	2	TiAlN	Mist Oil

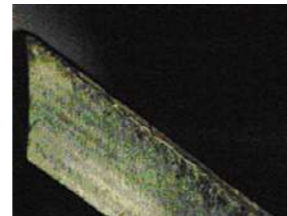
切削参数:
Cutting Conditions:

Vc=90m/min
fz=860mm/min
ae=0.8mm
ap=8mm

**LIFE
+66%**



O公司
Competitor O

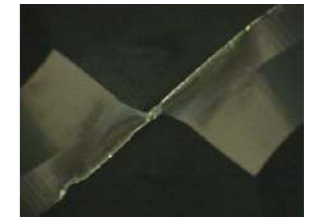
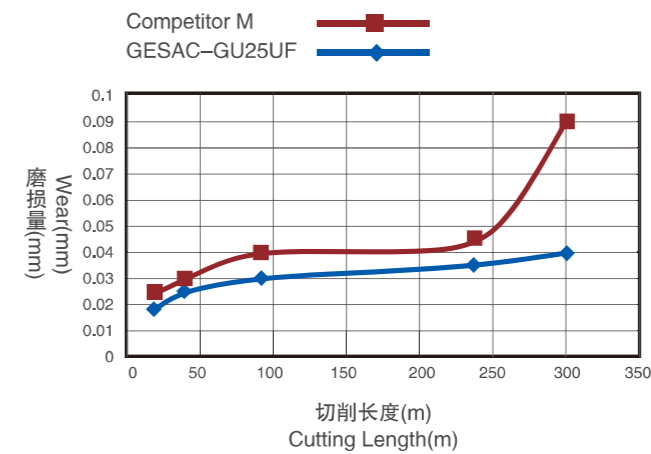


GESAC-GU20

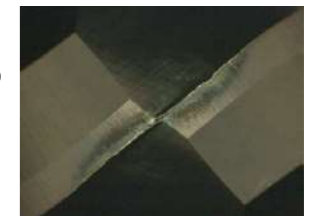
切削参数:
Cutting Conditions:

Vc=264m/min
Vf=4200mm/min
ae=0.2mm
ap=2mm

**LIFE
+75%**



M公司
Competitor M



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